

Work Order ID 69891

Tuesday, May 24, 2011 10:05:17 AM



Page 1

Item ID: D3572-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 5/24/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

cut 11/06/07

20 *0*

Jeaspa Bandsaw

Cut blank .500" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

cut 11/06/09

20 *0*

HAAS CNC vertical machine #1

1- Mill as per Folio FA685 Rev: *AA* & Dwg D3572 Rev: *D* ☐ 2-Deburr
per dwg D3572

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

cut 11/06/09

20 *0*

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Accept

Revision ID:

Item Name: Guide

Start Date: 5/24/2011 Start Qty: 20.00

Required Date: 5/31/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

SL 11/06/08



QC

Memo

0.00

Quality Control

(20)

140 Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

11/6/08 (20)

150 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13

MEF
11-06-10

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 10:05:43 AM

Page 1

Work Order ID: 69891

Parent Item: D3572-3

Parent Item Name: Guide



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B rev.B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No				f	21.9917		0.800400			



6061-T6 Bar .750 X 1.50



Location

Loc Qty

Loc Code

MAT003

21.9917

→ 116405

1.2497

116604

1.5

116623

19.242

0.800

mk 11/6/07

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69891

2811-05-24

RELEASED
09-04-28/11

D3572-041 GUIDE ASSEMBLY

D3572-043 GUIDE ASSEMBLY (UH-1)

D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
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DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
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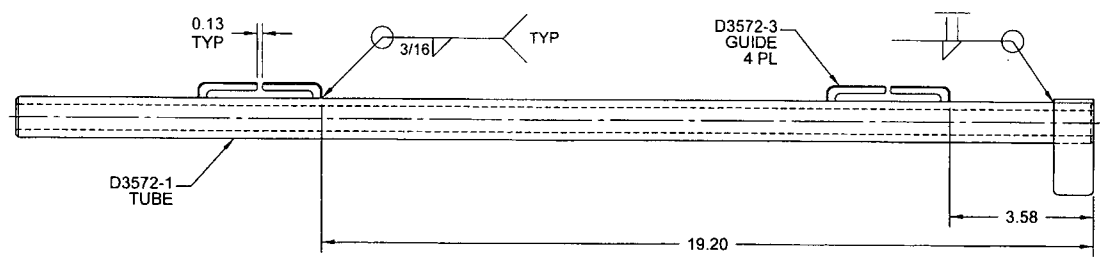
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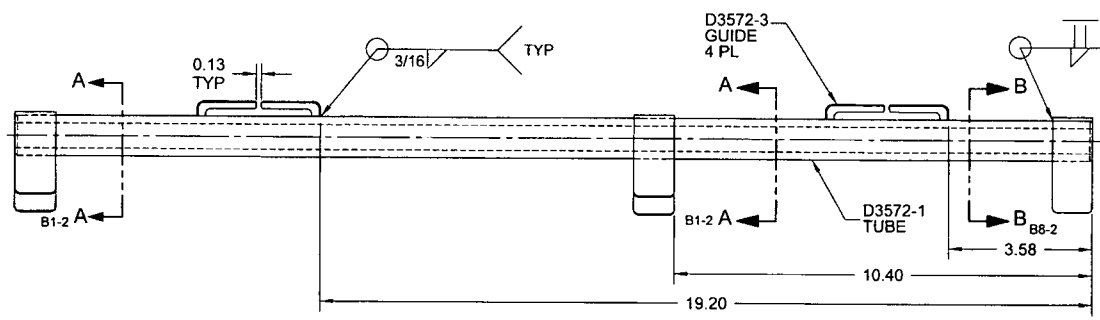
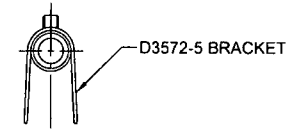
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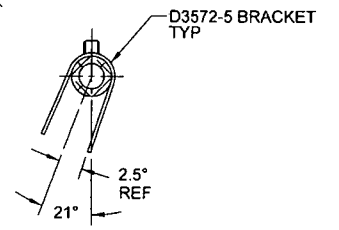
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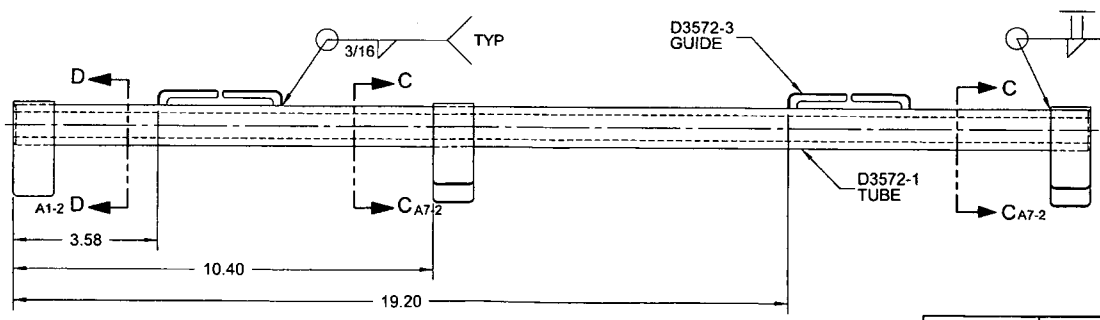
D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY

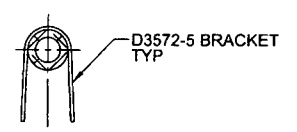


SECTION A-A
(2 PL) C7-2 C4-2



D3572-044 GUIDE ASSEMBLY

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09-04-17



SECTION D-D A7-2

SECTION B-B C2-2

SECTION C-C A2-2 A5-2

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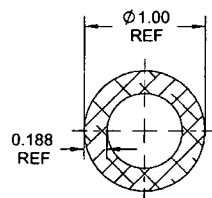
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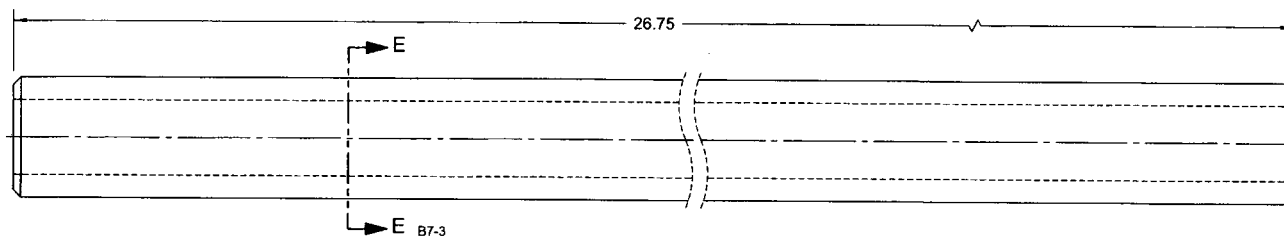
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

WLOG889



SECTION E-E C5-3



D3572-1 TUBE

0.06 X 45° CMF MIN

RELEASED
09/04/17 MP

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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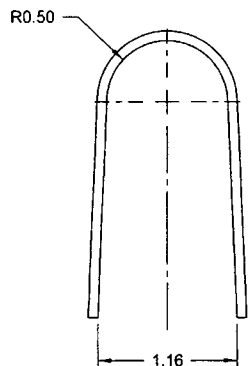
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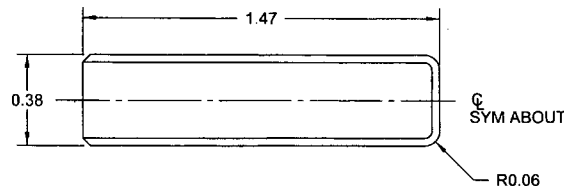
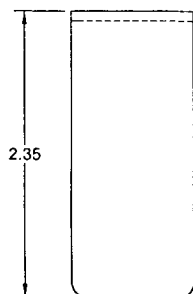
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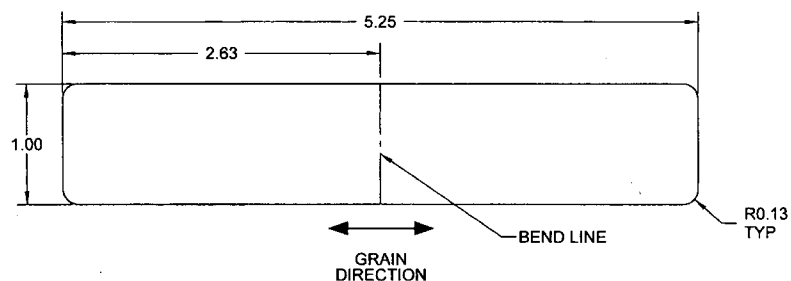
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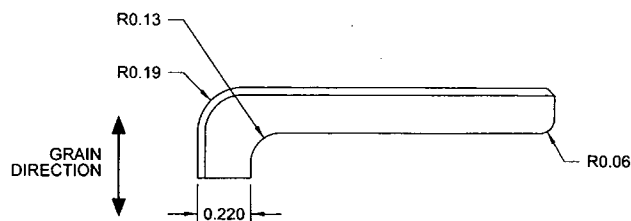
D3572-5 BRACKET
(MAKE FROM D3572-5F)



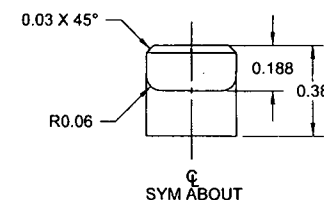
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D3572-5F FLAT PATTERN



D3572-3 GUIDE



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D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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